



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2801-041
Job Sheet 175545



Part No: D2801-041

Job Qty: 1 ea

Part Name: Step Assembly LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 5/18/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: D2801 REV:A1 IPP REV:A 14.04.15 NEW ISSUE DD VERF:JLM,

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/17/18	0.00	0.00	Start Up Large Fab-4		DC 2018-04-24
100	Large Fab	1 pcs		5/17/18	0.00	1.47	Large Fab 8		DC 2018-04-24
110	QC	1 pcs		5/17/18	0.00	0.00	QC6		CPC
120	Large Fab	1 pcs		5/17/18	0.00	1.47	Large Fab 2		CPC
130	QC	1 pcs		5/17/18	0.00	0.00	QC9		D1005-03
140	QC	1 pcs		5/17/18	0.00	0.00	QC5		D18-05-03
150	HandFinish	1 pcs		5/17/18	0.00	0.37	HandFinish1		SIA 18-05-04
160	QC	1 pcs		5/17/18	0.00	0.00	QC7-1		CPC
170	Large Fab	1 pcs		5/17/18	0.00	1.47	Large Fab 2		CPC
180	QC	1 pcs		5/17/18	0.00	0.00	QC10		14 2018-05-10
190	QC	1 pcs		5/17/18	0.00	0.00	QC5		14 2018-05-10
191	HandFinish	1 pcs		5/17/18	0.00	0.37	HandFinish2		SA 18-05-10
200	Powdercoat	1 pcs		5/17/18	0.00	0.24	Powdercoat1		BE 18-5-10
210	QC	1 pcs		5/17/18	0.00	0.00	QC3		BE 18-05-11
220	HandFinish	1 pcs		5/18/18	0.00	0.37	HandFinish4		BE 18-05-11
230	QC	1 pcs		5/18/18	0.00	0.00	QC5		38
240	Packaging	1 pcs		5/18/18	0.00	0.00	Packaging3-1		DAS 9-80
250	QC21-SA	1 Ea		5/18/18	0.00	0.00	QC21		21

Part Op 100 - 1-Cut D2622 extrusion to 86.15" long as per Dwg D2801 2-Deburr and bevel ends for welding

Descriptions: 120 - ***Press fit bushing before weldig*** 1-Weld Arms as per Dwg D2801 2-Weld (1) Cap as per Dwg D2801 3-Grind end cap welds flush

170 - 1-Weld last arm as per Dwg D2801 2-Weld last end cap as per Dwg D2801 3-Grind end cap welds flush Inspect for foreign object per QSI 024

191 - ***Touch up step with alodine per qsi 005 prior to powder coat***

200 - START TIME: 1:30 OVEN TEMPERATURE: 300° FINISH TIME: 2:00-

220 - Wing Walk per Dwg D2801 and QSI 005 4.4

Wing walk M138761

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 Ea (1 ea)	90-Start up Operation	5416116
D2734	Step End Plate	2 Ea (2 ea) 120	90-Start up Operation	5012001
D2802-1	Arm	2 (2 ea) 120	90-Start up Operation	F116467
D2808	Spacer	2 Ea (2 ea) 120	90-Start up Operation	F155607

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	211	0
	D2734	2	9	0
	D2802-1	2	0	0
	D2808	2	18	0
Part Specifications				
Specifications could not be found.				

Plex 4/6/18 10:35 AM dart.lacelle.linda

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OTHER : ☐					

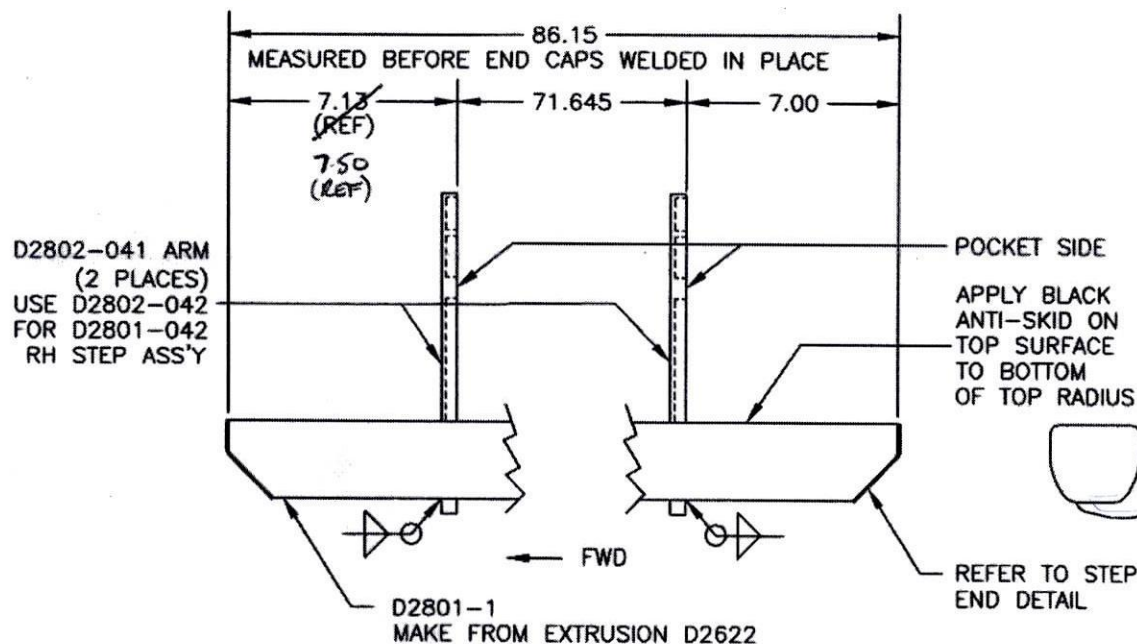
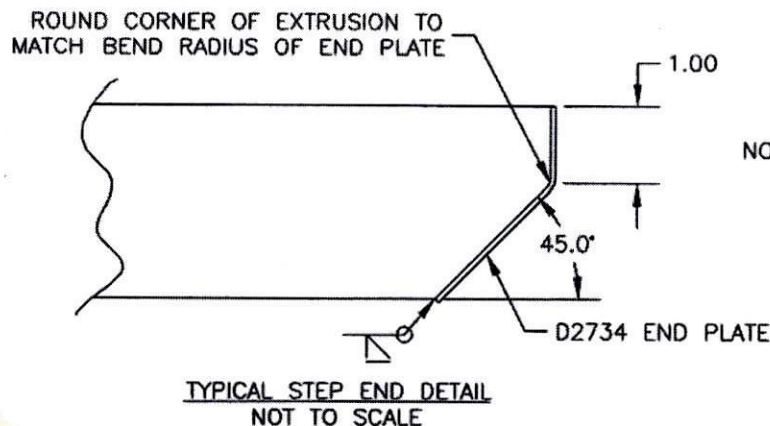
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
00.11.03	STEP WELDMENT	SHEET 1 OF 1
A	00.11.03	SCALE
A1	03.08.15	NTS
	NEW ISSUE	

RELEASED
00-11-13

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)

OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

ULT CATEGORY

☐ Power Loss/Surge	☐ Positioned Wrong
☐ Folio/Program	☐ Outside Dimensions
☐ Grain	☐ Over/Under tolerance
☐ Weld	☐ Part Incorrect
☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Out of Sequence	☐ Part Moved
☐ Off-set	☐ Drawing
☐ Mislabeled	☐ Finish
☐ Fit/Function	☐ Misread
☐ Misaligned/off center	☐ Turning Sequence

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 CANADA
 TEL.: 1 813 632-5200
 Email: sales@dartero.com
 www.dartaerospace.com

Date: 04/24/18



Container No: S064770



Part: D2801 - 041

Job No: 175545

Serial No/Batch: S064770

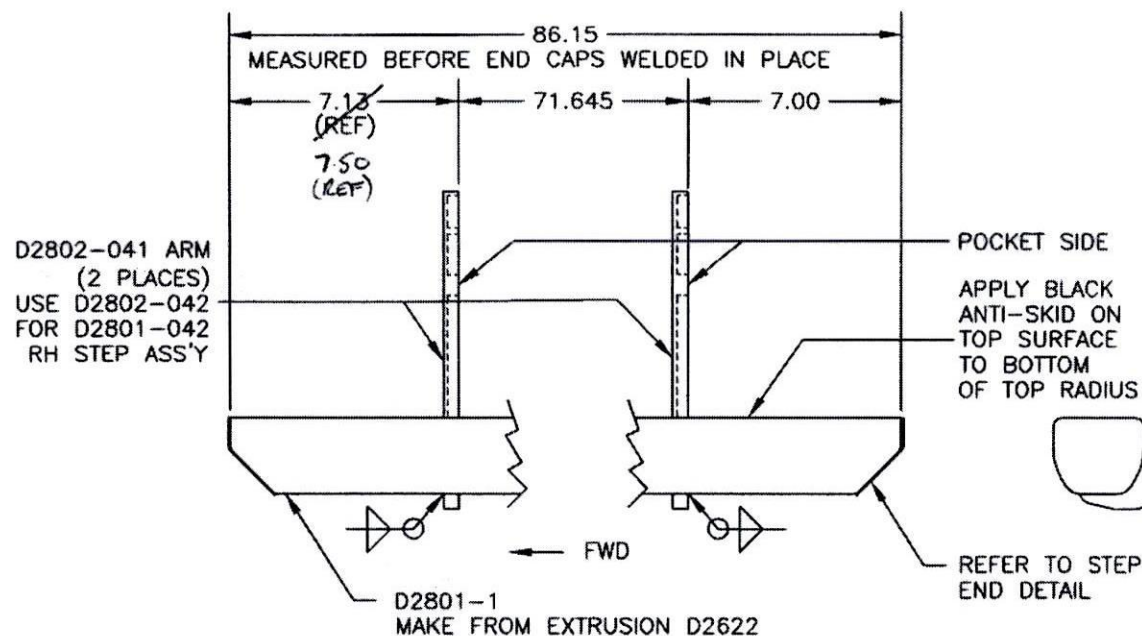
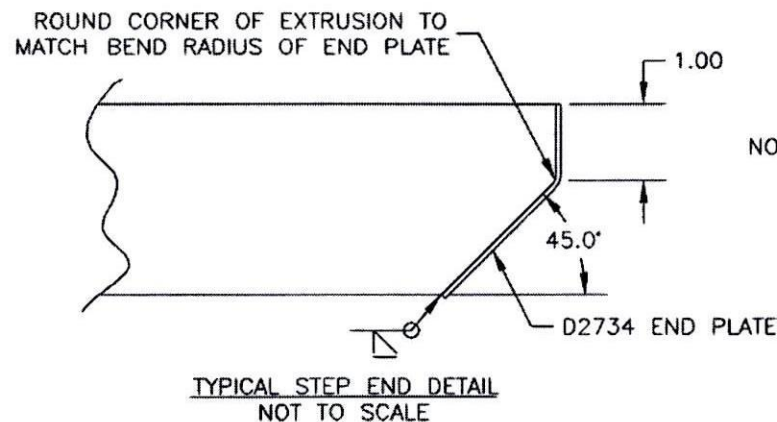
Revision: A1
Inspector:

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2801	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.03		STEP WELDMENT	NTS
A	00.11.03	NEW ISSUE	
A1	03.08.15	7.50 WTS 7.13	

RELEASED
00.11.13

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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OR BLACK SANDEX (4.3.5.7) OR GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3

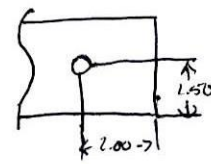
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

WORK ORDER NON-CONFORMANCE / UPDATE

DAS
53
9-89

Date:
Date: MAY 30 2018

Work Order update only ☐

Work Order: <u>17554+</u> Part No. <u>D2801-041</u> NCR No. <u>18-6882</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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 MS206 DIAD4W2R# 6138376-? Ø 0.129 CSK 0.225 x 100 OPTIONAL VENT HOLE for welding located on Surface - Plug with MS206 DIAD4W2R# AFTER welding prior to Finish				Acceptable. Same feature as other steps. No effect on step strength.				Cpl 18/5/8 Lead hand / / Super Approval Verific Cpl 18/5/8 QC / QA Coordir Approval PD 10-05-30																																																																									
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